

**Work Order ID 50235**

Page 1

July 14, 2009 10:31:06 AM

Item ID: D2857-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Jul 09/07/16

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2857	Rev B

100 0.00

BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 5.2"

09/07/24

12 0

110 0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio D2857-11j2-Deburr any rough edges

09/07/25

12 1

120 0.00

QC

Memo

Quality Control

09/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: N/A Fault Category: Prod. Eng. Control NCR: Yes No DQA: J Date: 09-06-05  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 09-06-17

NCR: 50235		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/25	110	One part after set up came too thin at the dimension of .147" came out at .131.	AFT 09.07.27 C255 042	Section w/ deviation is structural Not acceptable recommended scrap and replace	JL 09/07/25	S 09/07/26	RJ 09.07.27 C255 042	S 09/07/27
		R.C. Program error tool go too low.		110936 AFT				

NOTE: Date & initial all entries

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Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Draw  
Number

JL 090727

Draw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BL 09-07-28 ⑫.

Memo

0.00

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ S07/0768 ⑫ 6

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 50235**

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July 14, 2009 10:31:06 AM

Item ID: D2857-1

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

## Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powder Coating

Memo

0.00

START TIME:

3:30AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

M112148

09-07-29

X12

88

170



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

BL 09-07-29

(12)

180



Packaging

Identify as per dwg & Stock Location: 51

0.00

Packaging

Memo

0.00

C9/125 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

190



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

09/07/29 HJ

29-07-09 BL

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

July 14, 2009 10:31:05 AM

Work Order ID: 50235



Parent Item: D2857-1RevB



Parent Item Name: Hinge Bracket

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	36.0000	4.6053			

6061-T6 Bar 2.00 x 1.25



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	36	
105838	12	
110936	24	110936
		5.200

ML 09/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50285
Description: Hinge Bracket	Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.304	/			
4.000	+/-0.010	4.000	/			
0.340	+/-0.010	.345	/			
1.110	+/-0.005	1.111	/			
1.790	+/-0.010	1.794	/			
1.320	+/-0.005	1.319	/			
2.000	+/-0.010	2.004	/			
0.340	+/-0.010	.341	/			
0.447	+/-0.010	.449	/			
Ø0.171	+0.005/-0.000	.174	/			
0.147	+/-0.010	.148	/			
0.376	+/-0.010	.376	/			
0.126	+/-0.010	.119	/			
0.063	+/-0.010	.062	/			
Ø0.166	+0.005/-0.000	.166	/			
0.911	+/-0.010	.915	/			
0.600	+/-0.010	.605	/			
0.125	+/-0.010	.128	/			
0.150	+/-0.010	.147	/			

Measured by:	<i>SJ</i>
Date:	09/07/26

Audited by:	<i>JL</i>
Date:	09/07/27

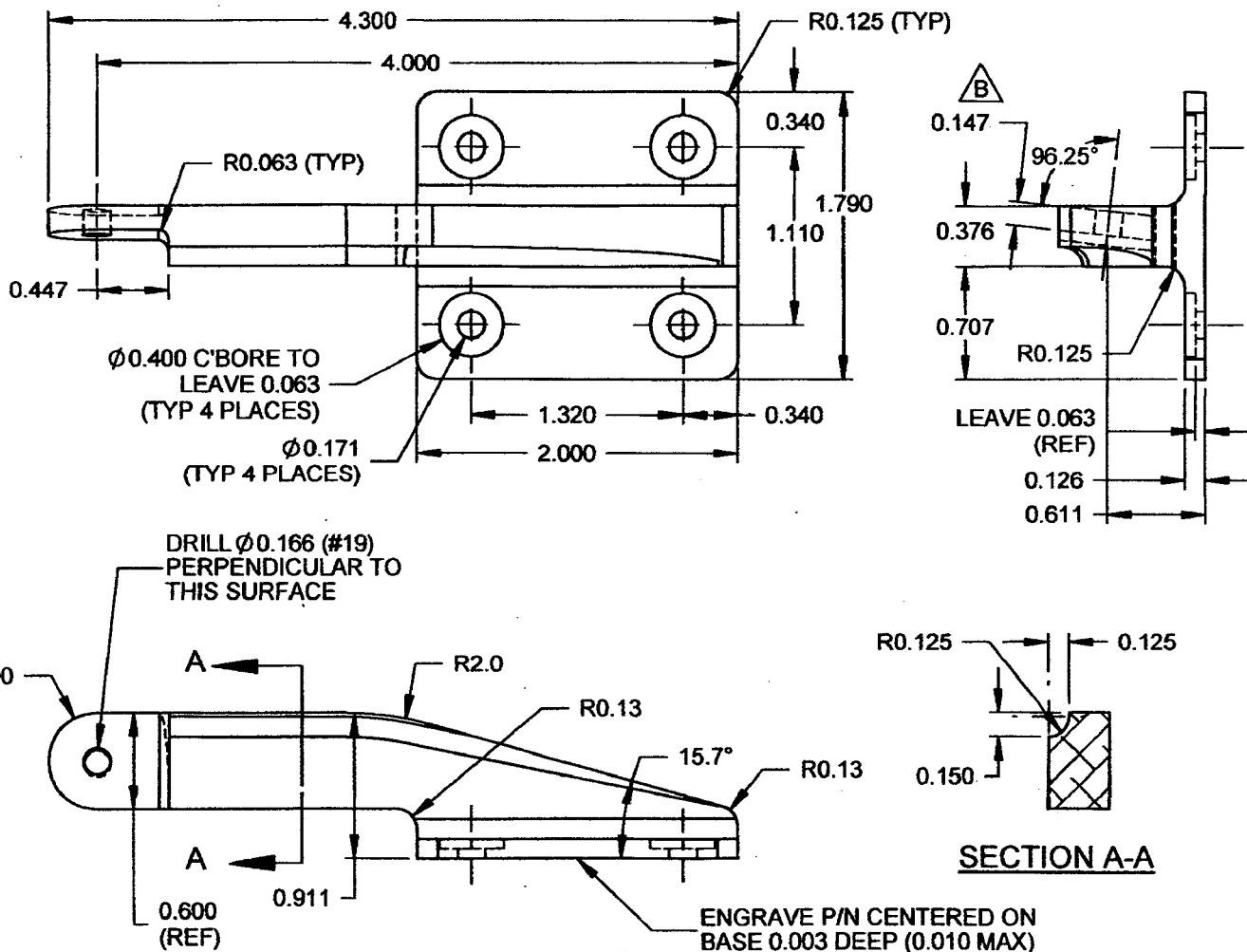
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>SJ</i>
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	<i>SJ</i>

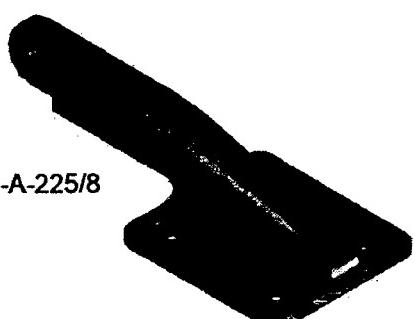
**DART**

DESIGN KE	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	REV. B SHEET 1 OF 1
DATE 06.08.28		TITLE <b>HINGE BRACKET</b>	SCALE 1:1
REV A	DATE 98.12.14	DESCRIPTION NEW ISSUE	
REV B	DATE 06.08.28	DESCRIPTION ADD THICKNESS, REDRAW W/ SOLIDWORKS	

**RELEASED**  
06-10-13



**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**



**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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